



LEICHTMETALL

DATA AND FACTS FOR APPLICATION

EN AW-6082

The multifaceted alloy

EN AW-6082 – THE ALLROUNDER

EN AW-6082 is a medium-strength, curable alloy, with its most outstanding characteristic being its multifunctionality. Its main properties are: very weather-proof, easily workable and reshapeable and very easily weldable. In order for this alloy to develop its full potential a heat treatment is necessary (solution annealing followed by progressive artificial aging). Ideal application areas: general machinery, the automotive sector as an electrical conductor or heat sink, and in the construction sector. Important: this alloy is not suited for the production of complex profiles.

Chemical Composition*

Si 0,7 1,3	Fe 0,50	Cu 0,10	Mn 0,40 1,0	Mg 0,6 1,2
Cr 0,25	Zn 0,20	Ti 0,10	others, each 0,05	others, total 0,15

*according to EN-573-3 or Teal-Sheets (AA)

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Mn	
0,4	1,0
Min-Value	Max-Value

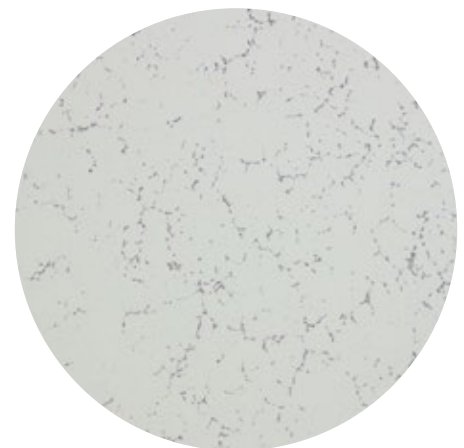
All values in mass %

Structure of the billets

Depending on the process, a segregation zone occurs immediately in the marginalized layer of continuously cast billets. Prior to further processing these should be removed – this is already the case for the turned billets from LEICHTMETALL. Additionally these billets are also subjected to a final quality test by means of an automatic ultrasonic test underwater. In the case of casting lengths, the depth of the segregation zone is shown by way of example at 178 mm.



Macrosection, d178 mm: Segregation 2,7 mm



Microsection, d178 mm (25 times magnification)

Casting Length Dimensions

Ø 160 mm	Ø 178 mm	Ø 200 mm	Ø 214 mm	Ø 226 mm	Ø 252 mm	Ø 278 mm
Ø 314 mm	Ø 349 mm	Ø 371 mm	Ø 424 mm	Ø 434 mm	Ø 519 mm	Ø 609 mm
Ø 682 mm	Ø 750 mm**	Ø 930 mm*	Ø 1150 mm**			

* Q4 2022

** Q2 2023

Turned billets

We can produce all diameters between 140 – 650 mm. From Q2 2023 onwards, we are able to produce diameters up to 1.100 mm.

Mechanical Properties

There is no standard for cast round rods (cast billets / bolts) that defines mechanical properties. A Brinell hardness in the homogenized state of approx. 46 HBW can be named as a guideline for cast material. The homogenized state (=„03“ according to EN515) is comparable in strength with the annealed state (=„0“) for extruded products. The final strength is essentially adjusted by the reshaping process and/or the heat treatments by our customers.

Profit from our extensive materials experience

We ship billets in the homogenized state (O3). The advantage: a consistent structure as well as good properties for further processing with reshaping processes (forging and extruding). We have summarized typical attainable empirical values from our experience – in relation to the heat treatments and resulting technological properties.

Physical Properties

Density	2,7 g/cm ³
Solidification range	585-650 °C
Electr. conductivity	24-32 MS/m
Thermal conductivity	170-220 W/(mK)
Modulus of elasticity	70.000 MPa
Specific heat	896 J/(kgK)
Shear modulus	26.400 MPa

Heat Treatment

Soft annealing, recrystallization annealing

Annealing temperature	380-420 °C
Heat-up time	1-2 h
Cooling conditions	> 250 °C: ≤ 30 °C/h ≤ 250 °C: in open air

Hardening

Solution annealing	525-540 °C
Quenching	air / water
Natural aging	5-8 days

Artificial aging

Temperature	155-190 °C
Duration	4-16 h

Mechanical Parameters

Condition	R _{p0,2} (MPa)	R _m (MPa)	A (%)
O	110	160	14
T4	110	205	14
T6	240	280	6

(all stated values for extruded round rods D. between 150 - 200 mm)

Technological Properties*

Weldability

Gas	o
WIG	+
MIG	++
Resistance welding	o

Surface treatment

Anodization protection	++
Anodization decorative	o
Coating	+

Cold reshapeability

Bending	o (condition T3, T4)
Deep-drawing / Pressing / Upsetting	+
Impact Extrusion	+

Corrosion resistance

Atmospheric conditions	++
Seawater	+

Brazeability

Hard soldering	o
Abrasion soldering	+
Soft soldering with flux	o

Hot reshapeability

Extrusion molding	+
Drop forging / Open die forging	+

Machineability

Annealed	o
Work-hardened	---
Hardened	+
Use in contact with food	Yes

* ++ = very good --- = not possible

Customer-Specific Solutions ...

Upon request we can adapt the analysis presets according to your individual processing needs and quality requirements. Various compositions are possible and similarly very pure alloys can be produced with limited amounts of Sodium, Calcium or Beryllium. We are looking forward to receive your request!

... no problem for LEICHTMETALL

High strength alloys are our Speciality. Our know-how as a foundry stretches back over 90 years. Today, demanding customers from many branches of industry – for example from Aviation, Automobile, general Machinery and Energy Management use the Premium Alloys made in Hannover, Germany. **Particularly close to our hearts, is our commitment to optimized production – saving energy and protecting the environment.** To that end, for example, we use secondary aluminium from the circular economy to ensure environmental and climate protection.



Do you have questions?

Please call us at +49 511 89878 475